

FDX 100 ACA

Product code: 265403601

Synthetic forming fluid

This product is a synthetic low viscosity water based evaporable fluid for forming applications. It is suitable for stamping, drawing of aluminium, steel, stainless steel strips and parts. The fluid is free of oils, solvents, silicones and chlorine and leaves a very thin film on the part that is compatible with paints, electroplating and welding. It is specially formulated with synthetic additives that provides very good lubrication in parts and tools.

Applications

It is suitable for a wide variety of forming operations from stamping up to tubes bending and deep drawing. It is easy to clean with tap water or any water based cleaner.

Benefits & Advantages

- Oil free
- Avoids harmful contact between part and dies
- Easy to apply
- Minimum defective parts
- Good corrosion protection on tools and dies
- Longer tools life
- Friendly for workers because of absence of solvents
- Compatible with refrigeration gasses

Typical Performance Data

Typical	Value
Appearance	Yellowish liquid
Density @ 20 °C, gr/cm ³	1.05
Viscosity @ 20 °C, cSt	3-6
Flash point, °C	none
pH	8.9

All performance data on this Technical Data Sheet are indicative only and can vary during production.

Use

The product is easy to mix. Simply pour the concentrate into water at the appropriate solution and mix. Hardness of the water should be between 100 ppm and 800 ppm and chloride content not higher than 200 ppm. It is normally recommended to use at 50% depending on the severity of the application. For severe operations use between 60-70%. For light operations use between 30-50%. Water hardness should be between 100 and 800 ppm, with chlorine content < 200 ppm.